

# Work Order ID 93495

**\*93495\***

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Thursday, November 15, 2012 2:53:44 PM

Item ID: PB67-43001-67

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 90° Blade Support Assembly

Start Date: 11/15/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/19/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-67	Rev C
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150

Weld per dwg A/R Aluminum rod Batch: M122324 0.00

**\*150\***

Large Fab

Memo

0.00

Large Fab

1- Install nut plates as per dwg

2- Weld assembly as per dwg B67-43001

**GRIND WELDS FLUSH**

160

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O 0.00

**\*170\***

QC

Memo

0.00

Quality Control

(9x) CC 12-11-27  
 (9x) Ae 12/11/28  
 (9) 12-11-30  
 (9) 12-11-30  
 D46 09 2-89

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Cust Item ID:

Required Date: 11/19/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

Identify as per dwg & Stock Location: *WMA*

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

*9 9 K*

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

*12/12/3 J*  
*MF 12-11-30*

# Picklist Print

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Work Order ID: 93495

Parent Item: PB67-43001-67

Parent Item Name: 90° Blade Support Assembly

Start Date: 11/15/2012

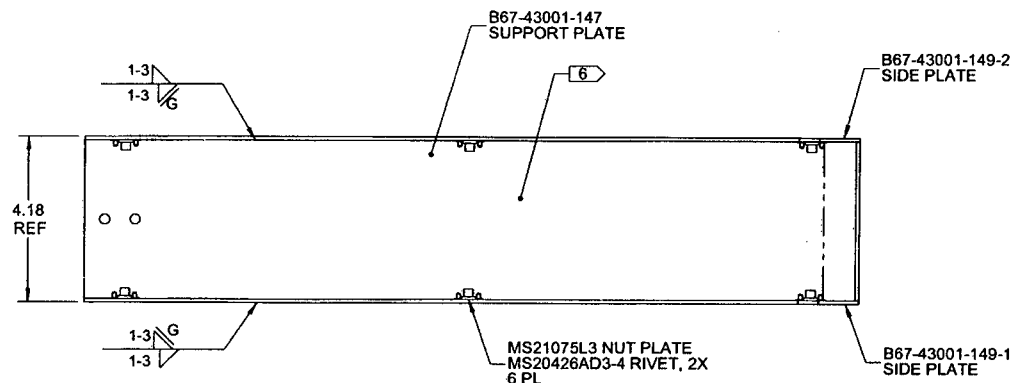
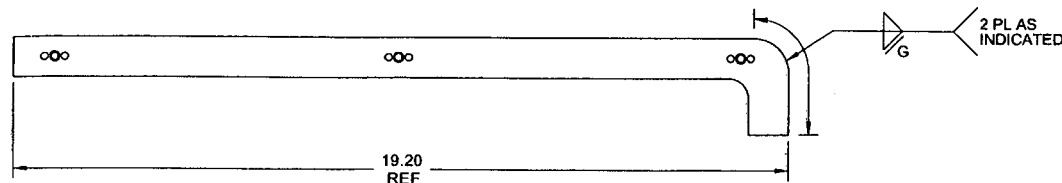
Required Date: 11/19/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec  
IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev B 10.09.30 per rev C  
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>MS21075L3</b> Nutplate		Purchased	No				Each	133.0000		60		12/11/29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST318		133							
				120910		1							
				121825		25							
				123346		10							
				123525		97							
<b>PB67-43001-047</b> Support Plate		Manufactured	No				Each	21.0000		10		12-11-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		21							
				52639		21							
<b>PB67-43001-049</b> Side Plate		Manufactured	No				Each	18.0000		20		12-11-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		6							
				41560		6							
				ST446		12							
				90905		12							
<b>MS20426AD3-4</b> RIVET		Purchased	No			100	Each	17,547.000	12	120		12/11/29	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		7713							
				104374		135							
				123352		7578							
				ST334		9834							
				123021		1834							
				123164		8000							



**B67-43001-67 90-DEGREE BLADE SUPPORT ASSY**

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) WELDING: PER QSI 004

ITEM	QTY -67	P/N	DESCRIPTION
1	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
2	1	B67-43001-147	SUPPORT PLATE
3	1	B67-43001-149-1	SIDE PLATE
4	1	B67-43001-149-2	SIDE PLATE
5	12	MS20426AD3-4	RIVET
6	6	MS21075L3	NUT PLATE

**RELEASED**  
2010-09-16  
WMD

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.		DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO. B67-43001-67		REV. C	
CHECKED		TITLE 90-DEGREE BLADE SUPPORT ASSY		SHEET 1 OF 1	
MFG. APPR.		SCALE		NTS	
APPROVED	WMD	DATE 10.04.28			
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			